

Edgetek™ CY1000 BL187

Polycarbonate + ABS

PolyOne Corporation

Message:

Impact modified

General Information			
Additive	Impact modifier		
Features	Impact modification		
Appearance	Grey		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	50.0	MPa	ASTM D638
Flexural Modulus ²	2100	MPa	ASTM D790
Flexural Strength ³	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	550	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	102	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	80 - 100	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	230 - 250	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	230 - 250	°C	
Mold Temperature	70 - 90	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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